Work Order ID 115141

Monday, March 17, 2014 2:48:42 PM

115141

Item ID: D2622-120C
Revision ID:
Item Name: Step Extrusion
Start Date: 4/14/14 **Start Qty:** 80.00
Required Date: 4/14/14 **Req'd Qty:** 80.00
Reference:

120
80
~~*80*~~

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** AA **Date:** 14-03-19
QC: **Date:**
Tooling: **Date:**
SPC (Y/N): **Date:**

Run Start *NR1*
Stop *NR2*

Draw Nbr	Revision Nbr
D2622	Rev C1

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	PURCHASING	0.00							
100 Purchasing		0.00							
Purchasing	**Memo** Issue P/O: 23479 a) Extrude as per Dwg D2622 Rev. Cb) Material: 6061-T6 (QQ-A-200/8)c) Minimum yield tensile strength = 35 ksid) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8%f) Order at 120" longg) Bon L Canada Inc.								
						CL 14/03/24	120		
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110 Packaging		0.00							
Packaging	**Memo** Ensure material certification is attached								
						14/06	126		
120	~~QC6~~ Inspect dimensions to drawing	0.00							
120 QC	Q48	0.00							
Quality Control	**Memo** Check Pull test per Dwg D2622 for compliance page attached Check hardness with Webster tester								
		SMD M/S/6				126 Can			Pho

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only [X]

Work Order: 115141

Part No. D2622-120C

NCR No. _____

DISPOSITION

Rework	
Scrap	
Use-as-is	
Suspected Unapproved	

AGAINST DEPARTMENT/PROCESS

Skid-tube		Crosstube		Water Jet	
Machining		Small Fab		Prod. Eng. Coor.	
Thermoforming		Finishing		Rec/Store/Packaging	
Large Fab		Composite		Supplier	

Engineering	
Quality	
Other	

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design					change sho to 018.			DAS 10 8-89		S 14/05/oc
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup		14/05/oc	# 120							
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear

- [] Bending
- [] Centre Not Concentric
- [] Cracks
- [] Crimp/Kink/Ripple/Wave
- [] Cuffs
- [] Crushing
- [] Heat Treat
- [] Inspection Strip in Tube
- [] Marks/Chatter
- [] Turning Sequence
- [] Wave/Twist in Tube

General

- [] Bend
- [] BOM/Route
- [] Broken/Damage/Defect
- [] Burrs
- [] Contamination
- [] Countersink
- [] Cut Too Short
- [] Drawing
- [] Drill Holes
- [] Finish
- [] Fit/Function
- [] Folio/Program
- [] Grain
- [] Hardware
- [] Inspection Incomplete/Unqualified
- [] Instructions Incomplete/Unclear
- [] Misaligned/off center
- [] Mislabeled
- [] Misread
- [] Off-set
- [] Out of Calibration
- [] Out of Sequence
- [] Outside Dimensions
- [] Over/Under tolerance
- [] Part Incorrect
- [] Part Lost/Missing
- [] Part Moved
- [] Positioned Wrong
- [] Power Loss/Surge
- [] Pressure/Forced
- [] Set-up
- [] Temperature/Cure
- [] Weld
- [] Wrong Stock Pulled
- [] Other

Work Order ID 115141

Monday, March 17, 2014 2:48:42 PM

115141

Item ID: D2622-120C
Revision ID:
Item Name: Step Extrusion
Start Date: 4/14/14 **Start Qty:** 80.00 *80*
Required Date: 4/14/14 **Req'd Qty:** 80.00 *80*
Reference:

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: WH.003	0.00				120	ø		14-05-07
130									
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00				MLJ	14-05-08		
140									
QC	**Memo**	0.00							
Quality Control									14-05-07

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

Monday, March 17, 2014 2:48:41 PM

Work Order ID: 115141 *115141*

Parent Item: D2622-120C *D2622-120C*

Parent Item Name: Step Extrusion

Start Date: 4/14/14 **Required Date:** 4/14/14

Start Qty: 80.00 **Required Qty:** 80.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120CP *D2622-120CP* Extrusion		Purchased	No			110	Each	0.0000	1 **	~~80~~ 120			

4/14/16 (126)

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
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☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

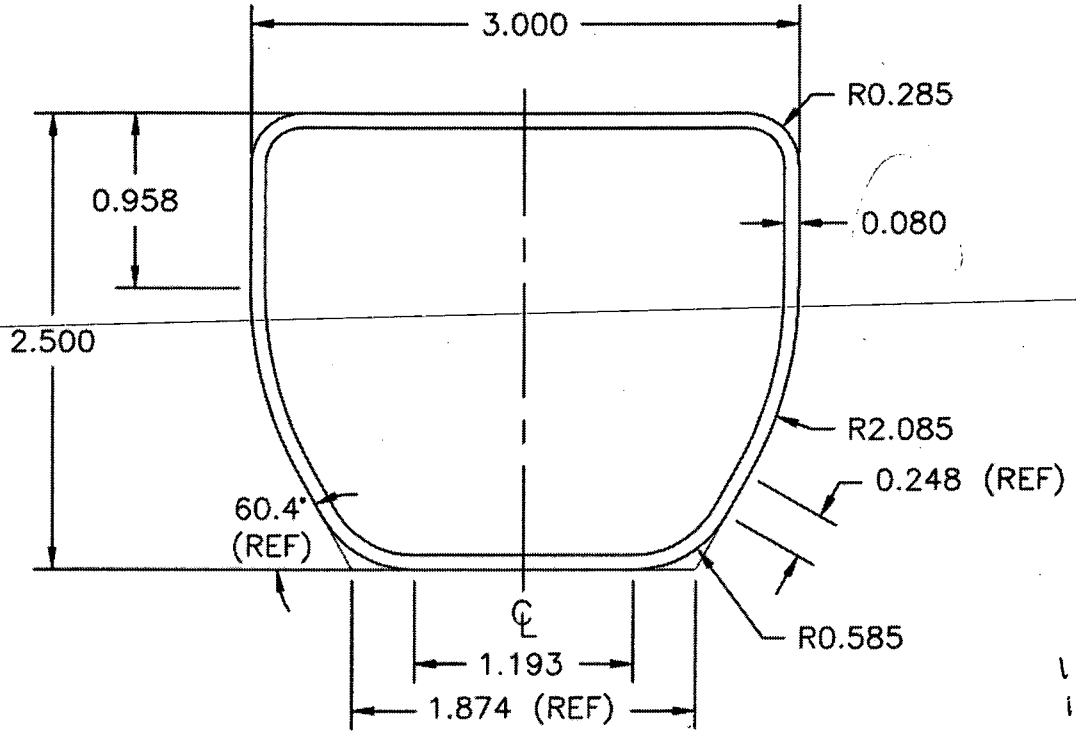
General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	GP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. C
		D2622 SHEET 1 OF 1
DATE		TITLE SCALE
02.09.11		STEP EXTRUSION 1:1

A	96.11.29	NEW ISSUE
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.
C1	GP 02.10.04	ADD 'REV. A' TO DIE NUMBER.

RELEASED
02.09.11



115141 MP
14-03-19

D2622–XXX STEP EXTRUSION

1) PART NUMBER IS D2622–XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622–120 IS 120" LONG)
2) MATERIAL 6061–T6 (QQ–A–200/8)
3) MANUFACTURED USING BON–L DIE # 897123 REV. A C1
4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

 MINIMUM TENSILE YIELD STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
 MINIMUM ELONGATION = 8%

5) PART IS SYMMETRIC ABOUT CENTERLINE
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23479

Purchase Order Date 3/24/2014
PO Print Date 3/24/2014

Order From : VC-BON001

SIGNATURE ALUMINUM CANADA INC.
C/O/ T10322C
P.O. BOX 4488, STN A
TORONTO, ON M5W 4H1
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		**Buyer**	Chantal Lavoie
Vendor Phone	905-427-6550	**Customer POID**	
		Customer Tax #	10127-2607
Ship To Contact		**Terms**	Net 30
Ship To Phone		**Currency**	CAD
Ship Via:	Yours ppd	**FOB**	Destination-Collect
Ship Acct:			

FAXED 04/03/26

Line Nbr	Reference / Vendor Part Number / Line Comments / Delivery Comments	Description / Mfg ID	Req Date / Taxable / Promise Date	CD	Req Qty / Unit of Measure	PO Unit Price	Extended Price
1	D2622-120CP	Extrusion	4/11/2014 Yes 4/11/2014		120.00 Each	$29.22	$3,506.78
	EXTRUDE AS PER DWG D2622 REV. C B115141 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS					**Line Total:**	**$3,506.78**
2	71401-45	PROCUREMENT QUALITY CLAUSES	4/11/2014 No 4/11/2014		1.00	$0.00	$0.00
	Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents						

Note:

signature aluminum CANADA INC.

1850 Clements Road, Pickering Ontario, Canada L1W 3R8
Phone: (866) 587-5780 Fax: (905) 427-2207
Visit us at www.signaturealum.com

PACKING LIST

ACCT# 46024

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST DATE / DATE DU BODEREAU	PACKING LIST NUMBER / N' DE BODEREAL	SALES ORDER NUMBER / N' DE COM
05-05-14	014934	113574

REFER TO THESE NUMBERS ON ALL CORRESPONDANCE

REFEREZ-VOUS A CES NUMEROUS POUR TOUTE CORRESPONDANCE

TERMS / FREIGHT
PP

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

LOCATION	TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP. DES VENTES
PIC	WILRIDE	042		R. BLAIS

CUSTOMER ID / ID DU CLIENT	ORDER DATE / DE LA COM	CUSTOMER PO NUMBER / CLIENT PO Nombre	JOB / FICHIER	FIELD SALES REP / REP REGIONAL DES VENTES	CUST SERVICE REP / REP. SERVICE CLIENTELE
46024	03/25/14	PO23479		G.ATTENBOROU	D1B
		BILL OF LADING NUMBER / NO. DE CONNAISSEMENT: 014934	CARRIER / TRANSPORTEUR: WILRIDE		

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO CUSTOMER PART NUMBER / NUMÉRO DE RÉFÉRENCE DU CLIENT	ALLOY & TEMPER / ALLIAGE & TEMPER LENGTH / LONGUEUR CUTTING TOLERANCE / Tolérance de coupe	FINISH DESCRIPTION / DESCRIPTION DE FINITION FABRICATION DESCRIPTION /DESCRIPTION DE FABRICATION SHIPPING TOLERANCE / EXPÉDITION TOLERANCE	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	1,094	LB		DAA-897123-2	6061 T6		3	1,157	1,118	LB	
	496	KG		D2622-120CP	120.0000 IN			525	507	KG	
	120	PC			Cut(+): 0.1180 Cut(-): 0.0000	Min: -10 % Max: 10 %			126	PC	
						833249 / 211647	1	139	126		14 PC
						833249 / 211648	1	509	496		56 PC
						833249 / 211649	1	509	496		56 PC

126

3	1,157	1,118	LB
	525	507	KG
		126	PC
TOTALS			

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

DATE OF DELIVERY

DRIVER

signature aluminum CANADA INC.

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS RD
PICKERING, ON L1W 3R8

CERTIFICATE OF COMPLIANCE

Cert Date	Cert No.	Sales Order	Page
05/03/2014	5326502	113574	1
Cust PO	**B/L No**	**Lot**	**Date**
PO23479	014934	833249	05/05/14

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-897123-2	10FT MILL 6061 T6	D2622-120CP

Gross Weight	1,157 LBS		
Net Qty	1,118 LBS	126 PCS	3 PKGS

Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-08	

Mechanical Tests:

Tensile MPA / KSI	Yield MPA / KSI	% Elongation	Conductivity	HRE
278.0 / 40.3	243.5 / 35.3	10.8	N/A	89

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.64	0.25	0.22	0.05	0.86	0.07	0.03	0.02	0.01

Dr 14/05/14
(certs only)

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical compositionfor the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2622-120C

DATE: 6 May 6th, 2014

PO / BATCH NO.: 23479/3/15/41

MATERIAL CERT REC'D: yes

QUANTITY RECEIVED: 126 pcs

QUANTITY INSPECTED: _____

QUANTITY REJECTED: _____

THICKNESS ORDERED: See attached # inspection sheets

THICKNESS RECEIVED: see attached inspection sheets

SHEET SIZE ORDERED: _____

SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	(N)	
CORRECT FINISH	(Y)	N	
CORROSION	Y	(N)	
CORRECT GRAIN DIRECTION	(Y)	N	
CORRECT MATERIAL	Y	N	
CORRECT THICKNESS	(Y)	N	
PHOTO REQUIRED	Y	N	
CORRECT MATERIAL	Y	N	AMS-QQ-2008
CORRECT REF # TO LINK CERT	Y	N	PO 23479
CORRECT MATERIAL IDENTFICATION	Y	N	
CORRECT M# ON THE MATERIAL	Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	N	
DOES THIS REQUIRE AN EXTRUSION REPORT	(Y)	N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK.
RECORD RESULTS BELOW

	HRC	HRB	DUR A	DUR D	
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: DAS 27 9.89	SIGNED OFF BY: _____
DATE: 5/5/14	DATE:

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

1- VERIFY STOCK TO DART PURCHASE ORDER
2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
5- VERIFY MATERIAL CERTS ARE CORECT TO THE DART PO INSTRUCTIONS
6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

1- VERIFY TO DART SUPPLIED DRAWING
2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVIED INTO DART
3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
6- INSPECT ALL DIMS AS PER DRAWING REQUIRMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

1- VERIFY MATERIAL CERTS MATCH THE REQUIRMENTS ON THE DART DRAWINGS
2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVIED INTO DART
3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 b. OUTSIDE DIAMETETER HIGHEST/LOWEST BOTH ENDS
 c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
4- IDENTFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC CORRDINATOR BEFORE GOING FURTHER

DART AEROSPACE LTD

Description:	Step Extrusion	**Work Order:**	1511541
Inspection Drawing:	52622	**Rev:**	C1
Part Number:	52622-120C		

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/- 0.010	2.527	✓		QC1-07	VerN
0.958	+/- 0.005	9.61	✓		"	
60.4 %	+/- ½	60.4 %	✓		"	S
1.193	+/- 0.005	1.195	✓		"	
1.874	+/- 0.005	1.879	✓		"	
0.080	+/- 0.005	0.0799	✓		"	
0.285 RO	+/- 0.005	.285	✓		"	
120"	+/- 0.100	120"	✓		QC1-12	Tape
3.000	+/- 0.	3.006	✓			

Measured by: SMD	**Checked By:** DAS 27	**QC inspector:**	**Engineering Approval** (*if necessary*)**:**
Date 14/5/6	**Date** 14/5/18	**Date**	**Date**

DART AEROSPACE LTD

Description:	Step Expansion	**Work Order:**	B11514
Inspection Drawing:	D2622	**Rev:** C1	**Part Number:** D2622-120C

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/-.000	2.535	✓		QCF 07	VerN
0.958	+/-.005	0.960	✓		"	
60.4 %	+/- 1/2	60.4 %	✓		"	S
1.193	+/-.000	1.999	✓		"	
1.874	+/-.000	1.880	✓		"	
0.080	+/-.005	0.0785	✓		"	
0.285 RO	+/-.005	0.285	✓		"	
120°	+/-0.100	120°	✓		QCF-12	Top
3.000	+/-0.	2.999				

Measured by: SMA **Date** 1/5/16	**Checked By:** **Date**	**QC inspector:** **Date**	**Engineering Approval** (*if necessary*)**:** **Date**

DART AEROSPACE LTD

Description:	Step Extrusion	**Work Order:**	1311514
Inspection Drawing:	D2622	**Rev:**	C1
Part Number:	D2622-120C		

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/-.000	2.524	✓			VeN
0.958	+/-.005	0.963	✓			
60.4°	+/- ½	60.4°	✓			S
1.193	+/-.000	1.196	✓			
1.874	+/-.000	1.878	✓			
0.080	+/-.005	0.0785	✓			
0.285 RO	+/-.005	.285	✓			
120"	+/-0.100	120"	✓		QCT-12	Tape
3.000	+/-0.	3.000				

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
Date 4/5/18	Date	Date	Date

DART AEROSPACE LTD

Description:	Step Extrusion	**Work Order:**	151514
Inspection Drawing:	D2622	**Rev:** C1	**Part Number:** D2622-120 C

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/- .000	2.502	✓			VerN
0.958	+/- .005	0.960	✓			
60.4°	+/- ½	60.4	✓			S
1.193	+/- .000	1.196	✓			
1.874	+/- .000	1.875	✓			
0.080	+/- .005	0.075	✓			
0.285 RO	+/- .005	.285	✓			
120"	+/- 0.100	120"	✓		QCF-12	Tape
3.000	+/- 0.	3.002	✓			

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
Date SHP 14/5/16	Date	Date	Date

DART AEROSPACE LTD

Description:	Step Extrusion	**Work Order:**	1511514
Inspection Drawing:	D2622	**Rev:** C1	**Part Number:** D2622-120C

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/- 0.005	2.520	✓		QSF-07	Vern
0.958	+/- 0.005	0.959	✓		"	
60.4°	+/- ½	60.4	✓		"	S
1.193	+/- 0.005	1.196	✓		"	
1.874	+/- 0.005	1.877	✓		"	
0.080	+/- 0.005	0.075	✓		"	
0.285 RO	+/- 0.005	0.285	✓		"	
120"	+/- 0.100	120"	✓		QCF-12	Tape
3.000	+/- 0.	3.000				

Measured by:	Checked By:	QC inspector:	Engineering Approval *(if necessary)*:
SMP			
Date 14/5/16	Date	Date	Date

DART AEROSPACE LTD

Description:	Step Extrusion	**Work Order:**	151514
Inspection Drawing:	D2622	**Rev:**	C1
Part Number:	D2622-120C		

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/- 0.005	2.5003	✓			VeN
0.958	+/- 0.005	0.964	✓			
60.4°	+/- ½	60.4°	✓			S
1.193	+/- 0.005	1.195	✓			
1.874	+/- 0.005	1.880	✓			
0.080	+/- 0.005	0.0746	✓			
0.285 RO	+/- 0.005	.285	✓			
120"	+/- 0.100	120"	✓		QCF-12	Tape
3.000	+/- 0.	3.000	✓			

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
SMD			
Date 4/5/16	Date	Date	Date

DART AEROSPACE LTD

Description:	Step Extrusion	**Work Order:**	511514
Inspection Drawing:	D2622	**Rev:**	C1
Part Number:	D2622-120C		

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/- 0.010		✓			VAN
0.958	+/- 0.010		✓			
60.4 D/b	+/- ½		✓			S
1.193	+/- 0.010		✓			
1.874	+/- 0.010		✓			
0.080	+/- 0.010		✓			
0.285 RO	+/- 0.010		✓			
120"	+/- 0.100	120"	✓		QCF-12	Tape
3.000	+/- 0.					

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
Date	Date	Date	Date

DART AEROSPACE LTD

Description:	Step Extension	**Work Order:**	1511514
Inspection Drawing:	D2622	**Rev:**	C1
Part Number:	D2622-120C		

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/-.000	2.503	✓		QCI-07	VerN
0.958	+/-.006	0.960	✓		"	
60.4°	+/- ½	60.4°	✓		"	S
1.193	+/-.000	1.200	✓		"	
1.874	+/-.000	1.914	✓		"	
0.080	+/-.006	0.078	✓		"	
0.285 RO	+/-.006	0.285	✓		"	
120°	+/-0.100	120°	✓		QCI-12	Topo
3.000	+/-.000	2.997			QCI-07	

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
SMB			
Date 14/5/16	Date	Date	Date

DART AEROSPACE LTD

Description:	Step Extrusion	**Work Order:**	1511514
Inspection Drawing:	D2622	**Rev:** C1	**Part Number:** D2622-120C

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/- 0.010	2.505	✓		QCI 07	VerN
0.958	+/- 0.006	.968	✓		"	
60.4°	+/- ½	60.4	✓		"	S
1.193	+/- 0.010	1.195	✓		"	
1.874	+/- 0.010	1.879	✓		"	
0.080	+/- 0.010	0.0781	✓		"	
0.285 RO	+/- 0.006	0.285	✓		"	
120°	+/- 0.100	120°	✓		QCI-12	Topo
3.000	+/- 0.010	3.006	✓		QCI-07	

Measured by: SWP	Checked By:	QC inspector:	Engineering Approval *(if necessary)*:
Date 14/5/6	Date	Date	Date

DART AEROSPACE LTD

Description:	Step Extension	**Work Order:**	151514
Inspection Drawing:	D2622	**Rev:**	C
Part Number:	D2622-120C		

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/- 0.010	2.500	✓		QCF-07	Vern
0.958	+/- 0.005	0.960	✓		"	"
60.4°	+/- ½	60.4°	✓		"	S
1.193	+/- 0.010	1.199	✓		"	"
1.874	+/- 0.010	1.880	✓		"	"
0.080	+/- 0.010	0.0774	✓		"	"
0.285 RO	+/- 0.005	0.285	✓		"	"
120"	+/- 0.100	120"	✓		QCF-12	Tape
3.000	+/- 0.	3.004	✓		QCF-07	

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
Date SMP 14/5/16	Date	Date	Date

DART AEROSPACE LTD

Description:	Step Extension	**Work Order:**	1511514
Inspection Drawing:	D2622	**Rev:**	C1
Part Number:	D2622-120C		

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/- 0.010	2.504	✓		QCF-07	Vern
0.958	+/- 0.005	0.961	✓		"	
60.4 %	+/- 1/2	60.4	✓		"	S
1.193	+/- 0.010	1.200	✓		"	
1.874	+/- 0.010	1.881	✓		"	
0.080	+/- 0.010	0.077	✓		"	
0.285 RO	+/- 0.005	.285	✓		"	
120"	+/- 0.100	120"	✓		QCF-12	Tape
3.000	+/- 0.010	3.003	✓		QCF-07	

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
SKP			
Date 14/5/16	Date	Date	Date

DART AEROSPACE LTD

Description:	Step Extrusion	**Work Order:**	151514
Inspection Drawing:	D2622	**Rev:**	C1
Part Number:	D2622-120C		

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/-.005	2.505	✓		QCF-07	VAN
0.958	+/-.005	0.960	✓		"	
60.4°	+/- ½	60.4	✓		"	S
1.193	+/-.005	1.198	✓		"	
1.874	+/-.005	1.884	✓		"	
0.080	+/-.005	0.078	✓		"	
0.285 RO	+/-.005	.285	✓		"	
120°	+/-0.100	120°	✓		QCF-12	Tape
3.000	+/-0.010	2.999	✓		QCF-07	

Measured by:	Checked By:	QC inspector:	Engineering Approval *(if necessary)*:
SMP			
Date 14/5/16	Date	Date	Date

DART AEROSPACE LTD

Description:	Step Extrusion	**Work Order:**	131514
Inspection Drawing:	D2622	**Rev:** C1	**Part Number:** D2622-120C

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/-0.010	2.510	✓		QCF-07	Vern
0.958	+/-0.010	0.965	✓		"	
60.4°	+/- ½°	60.4°	✓		"	S
1.193	+/-0.010	11.938	✓		"	
1.874	+/-0.010	1.930	✓		"	
0.080	+/-0.010	0.077	✓		"	
0.285 RO	+/-0.010	0.285	✓		"	
120°	+/-0.100	120°	✓		QCF-12	Tape
3.000	+/-0.010	3.005	✓		QCF-07	

Measured by: SMP	**Checked By:**	**QC inspector:**	**Engineering Approval** (*if necessary*)**:**
Date 14/5/6	**Date**	**Date**	**Date**

DART AEROSPACE LTD

Description:	Step Extrusion	**Work Order:**	151514
Inspection Drawing:	D2622	**Rev:**	C1
Part Number:	D2622-120C		

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/- 0.010	2.503	✓		QCF-07	Ven
0.958	+/- 0.010	0.961	✓		"	
60.4°	+/- ½	60.4	✓		"	S
1.193	+/- 0.010	1.196	✓		"	
1.874	+/- 0.010	1.910	✓		"	
0.080	+/- 0.010	0.0765	✓		"	
0.285 RO	+/- 0.010	0.285	✓		"	
120°	+/- 0.100	120°	✓		QCF-12	Tape
3.000	+/- 0.010	2.998	✓		QCF-07	

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
SMP			
Date 14/5/16	Date	Date	Date

DART AEROSPACE LTD

Description:	Step Extrusion	**Work Order:**	151514
Inspection Drawing:	D2622	**Rev:** C1	**Part Number:** D2622-120C

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/-.005	2.502	✓		QCF-07	Vern
0.958	+/-.005	0.960	✓		"	
60.4°	+/- ½	60.4	✓		"	S
1.193	+/-.005	1.195	✓		"	
1.874	+/-.005	1.880	✓		"	
0.080	+/-.005	0.079	✓		"	
0.285 RO	+/-.005	0.285	✓		"	
120"	+/-0.100	120"	✓		QCF-12	Tape
3.000	+/-.005	3.004	✓		QCF-07	

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
Date 14/5/16	Date	Date	Date

DART AEROSPACE LTD

Description:	Step Extrusion	**Work Order:**	151514
Inspection Drawing:	D2622	**Rev:**	C1
Part Number:	D2622-120C		

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/- 0.010	2.505	✓		QCF-07	Ven
0.958	+/- 0.010	0.960	✓		"	
60.4 %	+/- ½	60.4	✓		"	S
1.193	+/- 0.010	1.195	✓		"	
1.874	+/- 0.010	1.875	✓		"	
0.080	+/- 0.010	0.078	✓		"	
0.285 RO	+/- 0.010	0.285	✓		"	
120"	+/- 0.100	120"	✓		QCF-12	Tape
3.000	+/- 0.010	2.997	✓		QCF-07	

Measured by: SHP	**Checked By:**	**QC inspector:**	**Engineering Approval** (*if necessary*)**:**
Date 14/5/16	**Date**	**Date**	**Date**

DART AEROSPACE LTD

Description:	Step Extrusion	**Work Order:**	151514
Inspection Drawing:	D2622	**Rev:**	C1
Part Number:	D2622-120C		

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/-.000	2.504	✓		QCF-07	VerN
0.958	+/-.006	0.966	✓		"	
60.4°	+/- ½	60.4	✓		"	S
1.193	+/-0.00	1.195	✓		"	
1.874	+/-.000	1.885	✓		"	
0.080	+/-.006	0.078	✓		"	
0.285 RO	+/-0.06	.285	✓		"	
120"	+/-0.100	120"	✓		QCF-12	Tape
3.000	+/-0.00	3.00	✓		QCF-07	

Measured by:	Checked By:	QC inspector:	Engineering Approval *(if necessary)*:
SHP			
Date 14/5/6	Date	Date	Date